

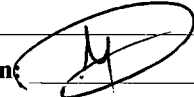
Work Order ID 139184

139184

Page 1

Thursday, February 11, 2016 3:38:57 PM

Item ID: PB67-43001-67 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: 90° Blade Support Assembly
 Start Date: 11/16/2015 Start Qty: 13.00 *13* Cust Item ID:
 Required Date: 12/11/2015 Req'd Qty: 13.00 *13* Customer:
 Reference:

Approvals: Process Plan:  Date: 16-2-11 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001-67	D

110 Weld per dwg A/R Aluminum rod Batch: 131562 0.00
 Large Fab

110

Large Fab

Large Fab

Memo

0.02

1- Install nut plates as per dwg

2- Weld assembly as per dwg B67-43001

3- Grind weld flush where indicated

13

FEB 24 2016

DAS
24
9-89

DAS
36
9-89

16/02/11

120 QC9- Inspect visual per QSI004- Fusion Welds 0.00

120

QC

Quality Control

Memo

0.00

13x

DAS
43
9-89

FEB 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 139184

139184

Page 2

Thursday, February 11, 2016 3:38:57 PM

Item ID: PB67-43001-67 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 90° Blade Support Assembly
Start Date: 11/16/2015 Start Qty: 13.00 ***13*** Cust Item ID:
Required Date: 12/11/2015 Req'd Qty: 13.00 ***13*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00						DAS 43	FEB 25 2016
130						<u>13x</u>		9-89	
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>WVA</u>	0.00						DAS 43	FEB 25 2016
140						<u>13x</u>		9-89	
Packaging	Memo	0.00							
Packaging	LOCATION: WA003								
150	QC21- Final Inspection - Work Order Release	0.00							
150						<u>MLJ</u>		FEB 25 2016	
QC	Memo	0.02							
Quality Control									

MLJ FEB 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Thursday, February 11, 2016 3:39:02 PM

Page 1

Work Order ID: 139184

139184

Parent Item: PB67-43001-67

PB67-43001-67

Parent Item Name: 90° Blade Support Assembly

Start Date: 11/16/2015

Required Date: 12/11/2015

Start Qty: 13.00

Required Qty: 13.00

Comments:

IPP Rev:A 08-06-19 new issue DD verified by:ec
 IPP Rev:B 08-09-23 remove alodine and QC3 DD verified EC IPP rev
 B 10.09.30 per rev C dwg EC verified by:DD
 IPP REV:C 14.12.15 DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS20426AD3-4		Purchased	No				Each	2,134.000		156			
MS20426AD3-4									**			16/02/11	DAS 36 9-89
RIVET													

Location	Loc Qty	Loc Code
GA	1650	
m131697	1650	
ST312	484	
m131697	484	

PB67-43001-147		Manufactured	No				Each	0.0000		13			
----------------	--	--------------	----	--	--	--	------	--------	--	----	--	--	--

PB67-43001-147

Support Plate

PB67-43001-149-1		Manufactured	No				Each	0.0000		13			
------------------	--	--------------	----	--	--	--	------	--------	--	----	--	--	--

PB67-43001-149-1

Side Plate

PB67-43001-149-2		Manufactured	No				Each	0.0000		13			
------------------	--	--------------	----	--	--	--	------	--------	--	----	--	--	--

PB67-43001-149-2

Side Plate

MS21075L3N M130799 ~~29x~~ 29x

M128429 30x

MS21075L3

M134257 19x

****B141745 12 B134791 1**

FEB 24 2016

****B141791 2x B141793 2x**

FEB 24 2016

****B141806 9x**

FEB 24 2016

****B141792 2x B141789 2x**

FEB 24 2016

16/02/11 DAS 36 9-89
 16/02/18 DAS 36 9-89
 16/02/18 DAS 36 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

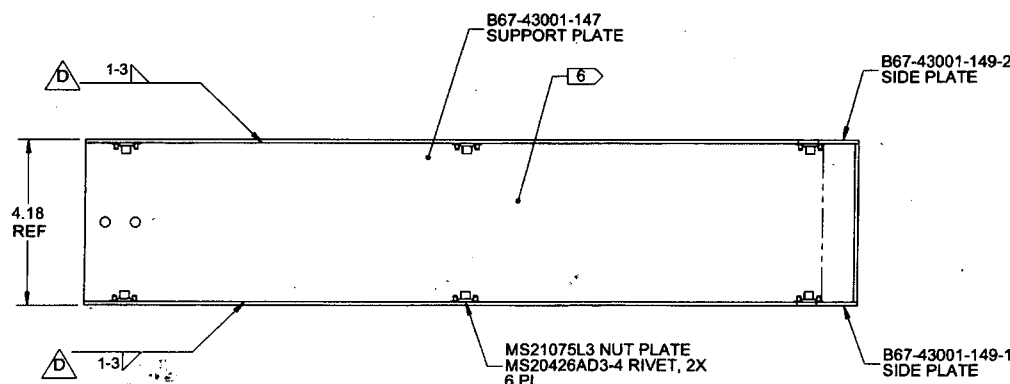
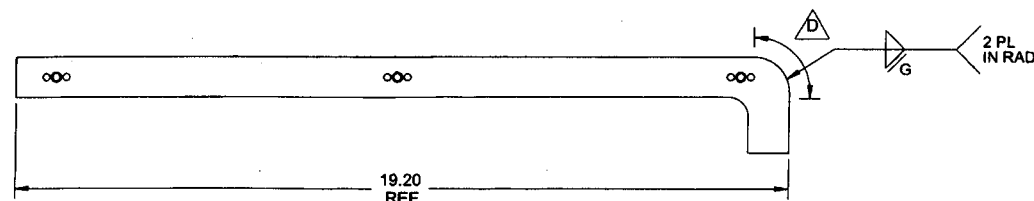
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

ITEM	QTY	P/N	DESCRIPTION
	X	B67-43001-67	90-DEGREE SUPPORT PLATE ASSY
1	1	B67-43001-147	SUPPORT PLATE
2	1	B67-43001-149-1	SIDE PLATE
3	1	B67-43001-149-2	SIDE PLATE
4	12	MS20426AD3-4	RIVET
5	6	MS21075L3	NUT PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 139184 MJS
15-12-03

RELEASED
2014-12-08

D	CHANGE WELD SYMBOLS TO REFLECT MANUFACTURING PRACTICE REASON: FACILITATE MANUFACTURING	DB	14.07.14	
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 9 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	10.04.28	
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	DB			
CHECKED	IR	DRAWING NO.	REV. D	
MFG. APPR.		B67-43001-67	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.	N/A	90-DEGREE BLADE SUPPORT ASSY	NTS	
DATE	14.07.14			
COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.				



B67-43001-67 90-DEGREE BLADE SUPPORT ASSY

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-67" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.11 lbs
 - 8) WELDING: PER QSI 004